

Work Order ID 50613

July 17 2009 9:02:56 AM



Page 1

Item ID: D3259-3
Revision ID: B Prototype
Item Name: Doubler

PROTOTYPE

Accept



Setup Start



Stop



Start Date: 07/17/2009 Start Qty: 200
Required Date: 07/24/2009 Req'd Qty: 200



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *mf*
QC:

Date: *09-07-17*
Date:

Tooling: *0*
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100	FLOW WATER JET	0.00
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Waterjet	Memo	0.00
110 CNC Waterjet	1-Cut as per Dwg D3259 Dwg Rev: <i>PLUTO</i> Prog Rev: <i>TYPE</i> 2-Deburr if necessary	

B9-7-20

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC	Memo	0.00
Quality Control		

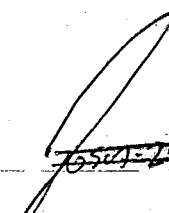
B9-7-20



120	QC8- Inspect parts - second check	0.00
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QC	Memo	0.00
Quality Control		

**ENGINEERING
APPROVAL**

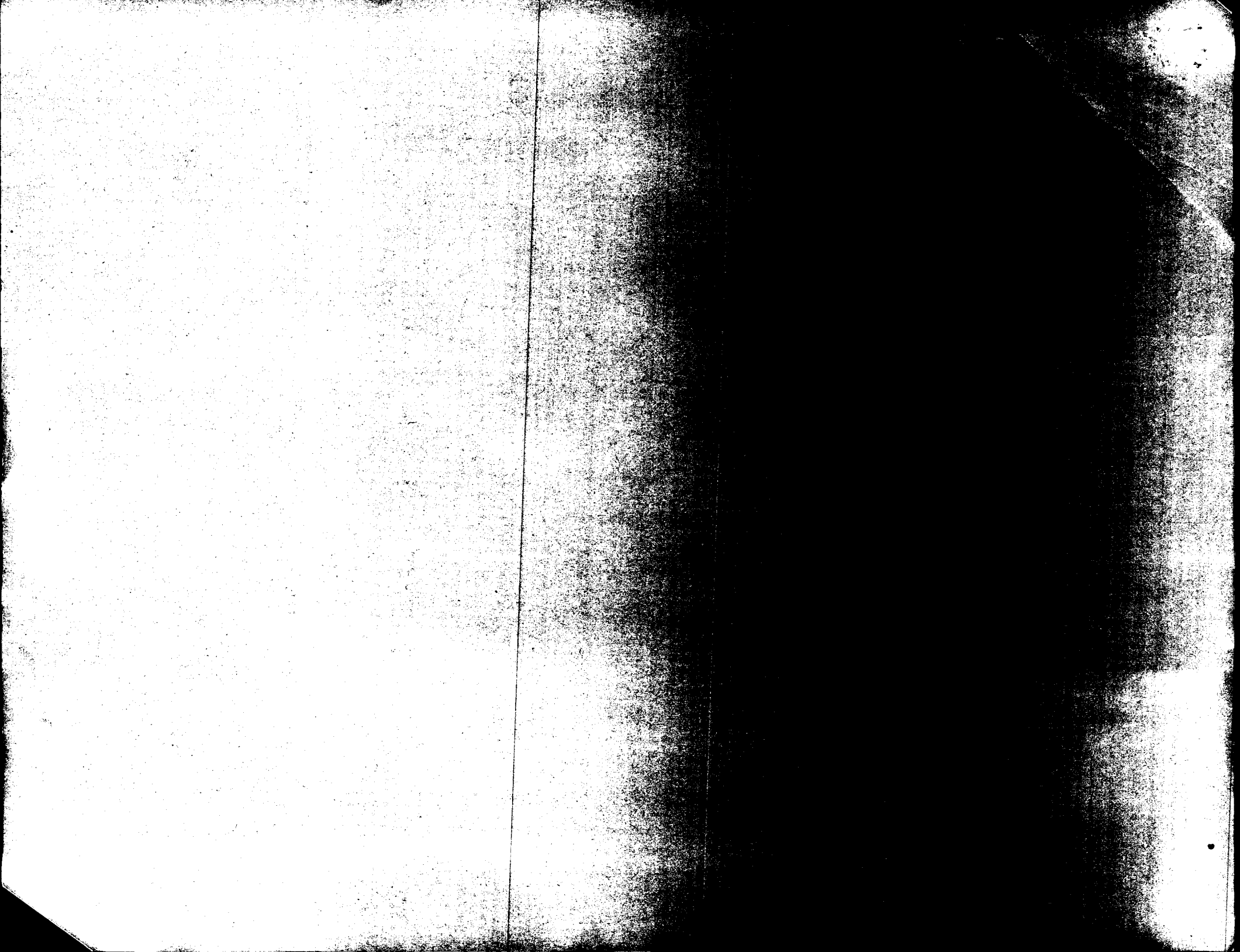


130 Small Fab

C'sink holes as per dwg

Rea/6/22

09/07/23 *(4)*



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Item ID: D3259-3
Revision ID: B Prototype
Item Name: Doubler

Accept

Setup Start

Stop

Start Date: 07/17/2009 Start Qty: 1.00

Required Date: 07/24/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3259

0.00

0.00

SB 07/07/09

4

P10

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

**ENGINEERING
APPROVAL**

10

41

CP 09.05.21

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

N/A

CP 09.05.21

WORK ORDER CHANGES


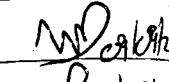
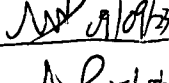
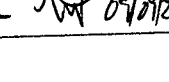

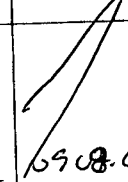
W/O:						Approval		Approval	
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Chief Eng / Prod Mgr
									QC Inspector

Part No: D 3259-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 50613

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-08-04	1410 130	Holes were c'sunk on the wrong side of the part. C'sunk holes were I.D'd on the drawing by (M.P.) Eng correction.		drawing was clear. Scrap & destroy ENG USE ONLY Replace. Qty 41 NOT REPLACED N/A. PROTO PIECE ONLY * Ensure to correctly understand the drawing prior to continuing work	CP 09.05.22 N/A 09.09.22 CP 09.05.22	  		

Initial all entries

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Item ID: D3259-3
Revision ID: B Prototype
Item Name: Doubler

Accept



Setup Start



Stop



Start Date: 07/17/2009 Start Qty: 1.00
Required Date: 07/24/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170
QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

N/A GP 09.09.21

180
Packaging
Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

N/A GP 09.09.21

190
QC
Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

FOR ENGINEERING USE ONLY

ENG USE ONLY 09.09.21
pull on w/c
ENG 0106-10
SEPT.

UMF
09-09-21

SECRET

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PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-705

Job #: ENG0106JUL

Date: 09.07.16

Product Name: Access Kit

Requested By: CP

Design Manager Approval: _____

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3259-3	SF	Doubler	09.07.07	N	09.08.04	The -3 now has a R0.25 bend, instead of R0.188. Flat pattern	
							chg'd as well. Need prototype to check bending. Should cut a	
							few extra to allow SF to play with the bending, if required.	

DART AEROSPACE LTD		Work Order:	50613
Description: DUBBLER		Part Number:	D3259-3
Inspection Dwg: D3259-3 Rev: PROTO TYPE		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X			
Ø .128	+ .005 - .001	.132	X			
Ø .377	+ .006 - .001	.378	X			
.500	+/- .010	.501	X			
.760	+/- .010	.760	X			
.974	+/- .010	.980	X			
9.000	+/- .010	9.000	X			
1.801	+/- .010	1.801	X			
.525	+/- .010	.525	X			
3.500	+/- .010	3.496	X			
.875	+/- .010	.876	X			
.525	+/- .010	.525	X			
1.279	+/- .010	1.280	X			
11.250	+/- .010	11.248	X			
12.000	+/- .010	11.998	X			
1.000	+/- .010	.998	X			
16.70	+/- .030	16.70	X			
.875	+/- .010	.873	X			
.525	+/- .010	.527	X			
.875	+/- .010	.873	X			
1.779	+/- .010	1.779	X			
5.000	+/- .010	4.994	X			
1.000	+/- .010	1.001	X			
.063	+/- .010	.062	X			

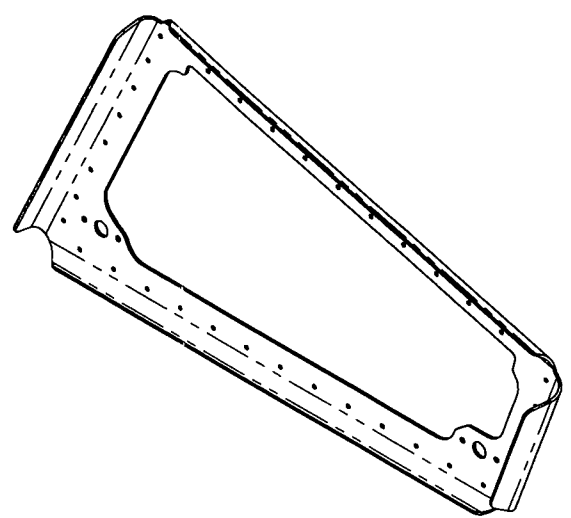
Measured by:	JB
Date:	9-7-20

Audited by:	
Date:	10-9-22

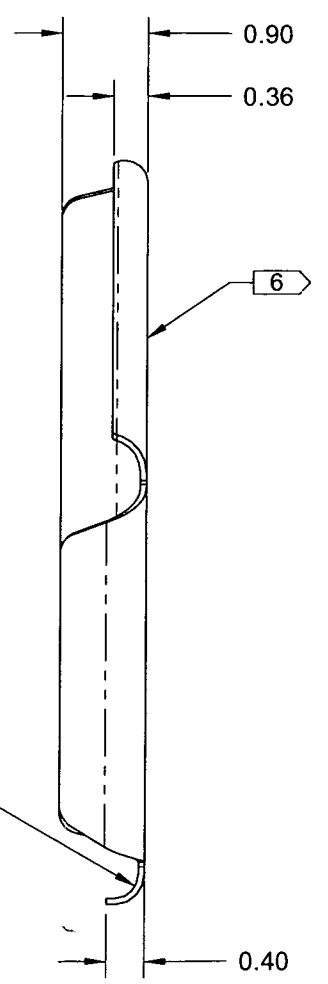
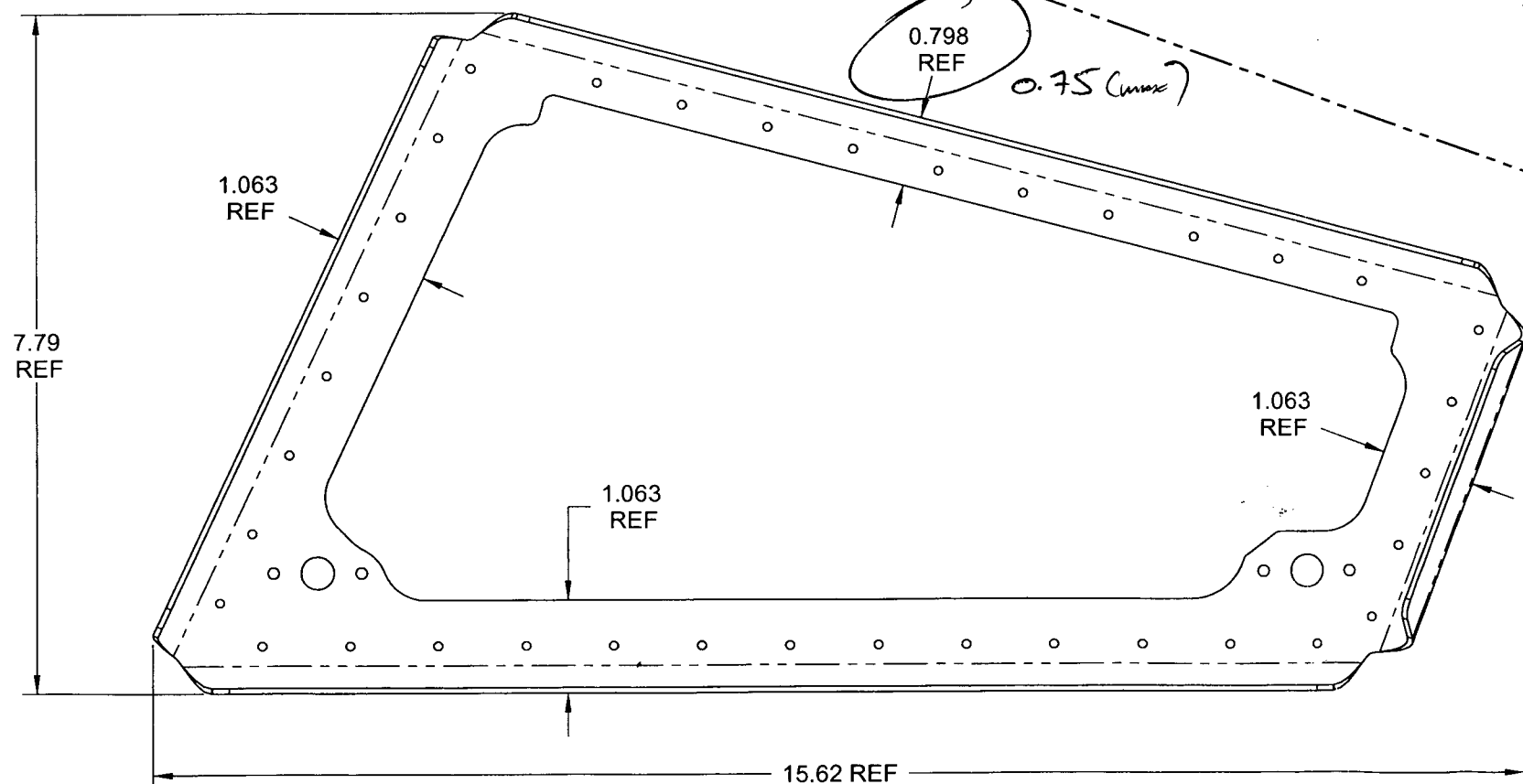
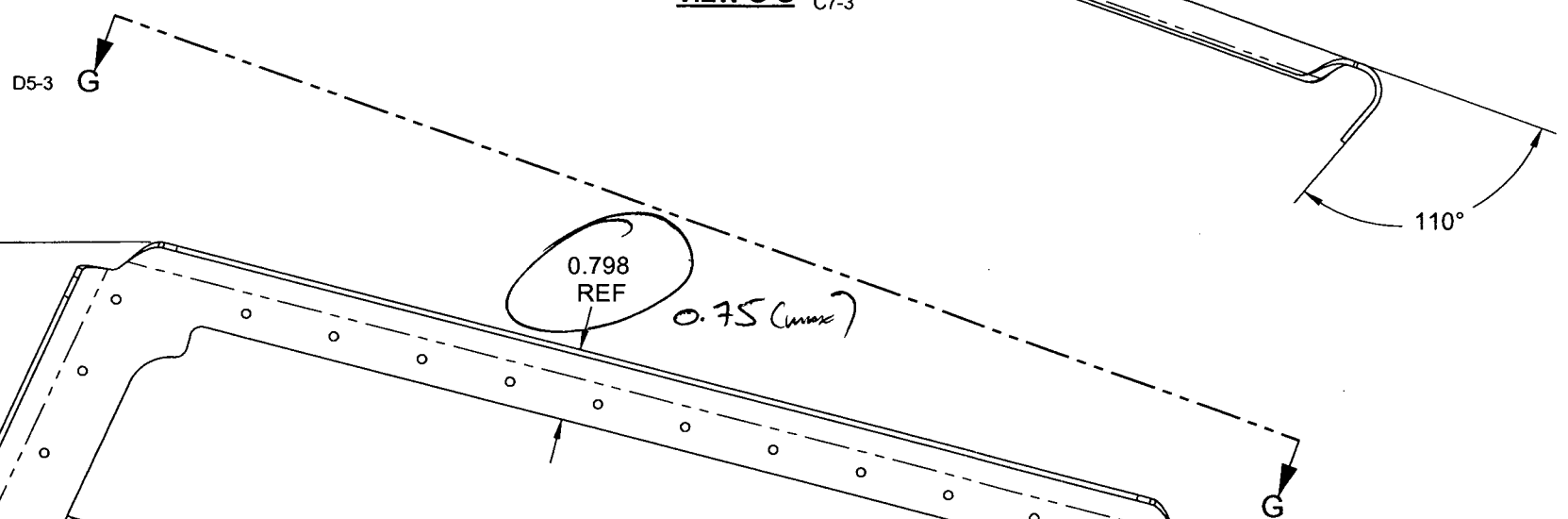
Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.07




VIEW G-G C7-3



R0.250
TYP

D3259-3 DOUBLER

- NOTES:
- 1) MATERIAL: MAKE FROM D3259-3F
 - 2) FINISH: ~~CHEMICAL CONVERSION COAT PER DART QSI 005 4-1~~ N/A 09.07.16
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TITLE	NTS
DATE	09.07.07	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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